

for -013 four steps to ship
mid NW!

Dart Aerospace Ltd.

Date: Monday, 10/22/2007 3:59:51 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35309
Estimate Number : 11027
P.O. Number : *N/A*
This Issue : 10/22/2007 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : MACHINED PARTS
Previous Run : 28156

Drawing Name : ARM
Part Number : D28021
Drawing Number : D2802 REV A
Project Number : N/A
Drawing Revision : A
Material : *N/A*
Due Date : 11/10/2007

Qty: *8* Um: *8* Each

Written By : *JA*
Checked & Approved By : *JA 07.10.23*
Comment : Est:B 02.03.18 Re-format NG
Est:C 06.02.13 Removed p/c EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X06000 6061-T6 Bar .50" x 6.0"



Comment: Qty.: 1.5750 f(s)/Unit Total : 12.6000 f(s)
6061-T6 Bar .50" x 6.0"
Material: 6061-T6 bar 6.00" x 0.50"
Batch: *M106027*

mk 07/11/07

(8)

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut blanks 17.800" long

mk 07/11/07

(8)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per folio FA101
Counter sink .375 dia as per dwg

J.F. 07/11/09

(8)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/11/09

(8)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

mk 07/11/010

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/11/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:59:51 PM
User: Kim Johnston

Process Sheet

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Drawing Name: ARM

Job Number: 35309

Part Number: D28021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr NO sharp edges.

ml 02/11/12

(8)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 02-11-12

(8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *mta*

ml 02-11-15

8

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ml 02/11/15

(8)

Job Completion



U 07.11.15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35309
Description: Arm		Part Number:	D2802-1
Inspection Dwg: D2802 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.494"	✓			
Ø0.191	+0.005/-0.001	Ø 0.191"	✓			
1.500	+/-0.010	1.504"	✓			
0.100	+/-0.010	0.110"	✓			
9.358	+/-0.010	9.358"	✓			
Ø0.507	+0.000/-0.001	Ø 0.507"	✓			
2.033	+/-0.010	2.034"	✓			
1.000	+/-0.010	1.000"	✓			
2.000	+/-0.010	2.005"	✓			
1.347	+/-0.010	1.352"	✓			
R0.75	+/-0.030	R0.750"	✓			
R0.300	+/-0.010	R 0.300"	✓			
R0.125	+/-0.010	R.125"	✓			
0.500	+/-0.010	0.505"	✓			
0.125	+/-0.010	0.120"	✓			
Ø0.507 x 0.250	+0.000/-0.001 x +/-0.010	Ø 0.507x.255"	✓			
Ø0.375 x 100°	+/-0.010 x 0.5°	Ø0.380x100°	✓			
0.250	+/-0.010	0.257"	✓			
R0.032	+/-0.010	R.032"	✓			

Measured by:	JF
Date:	07/11/09

Audited by:	JAL
Date:	07/11/10

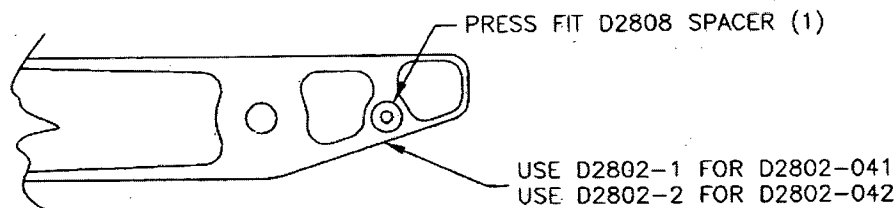
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	JAL

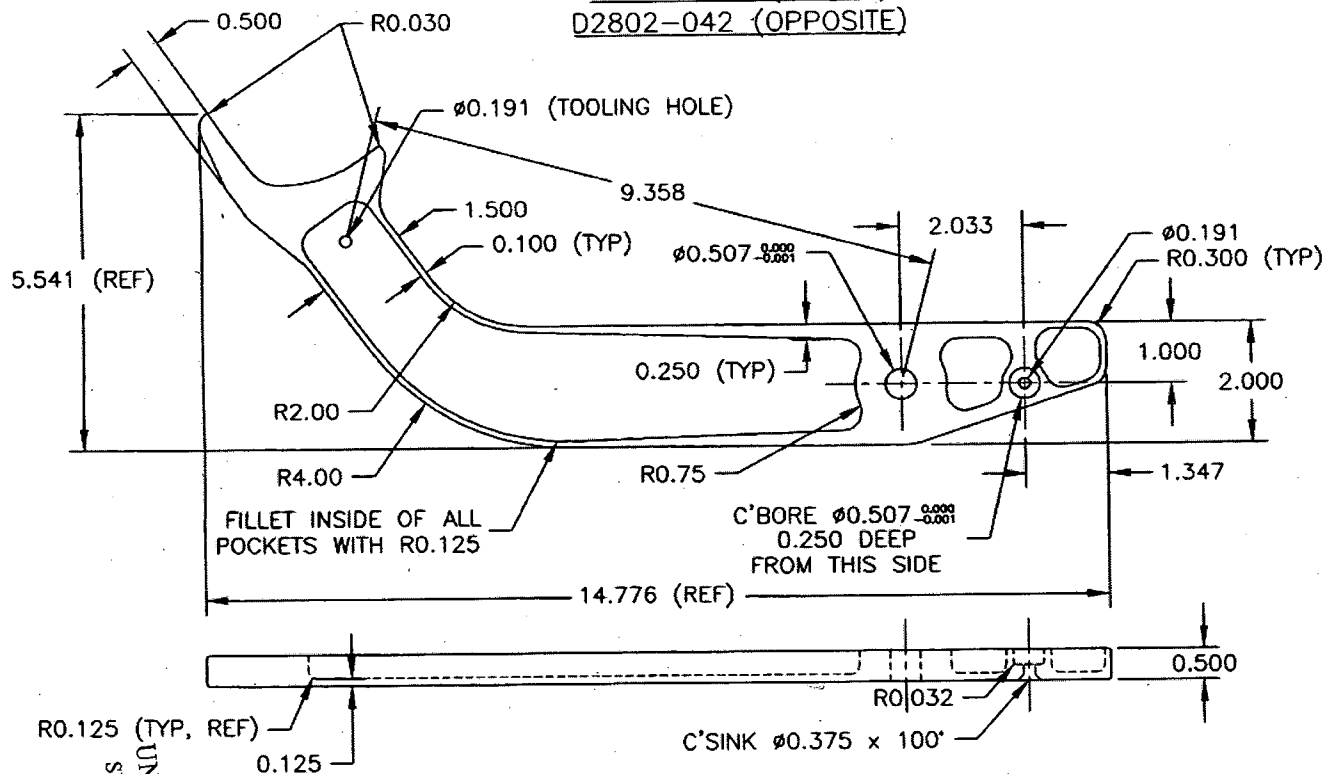
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>CP</i>	APPROVED <i>CP</i>	HAWKESBURY, ONTARIO, CANADA
DATE 00.11.03	DRAWING NO. D2802	REV. A
	TITLE ARM	SHEET 1 OF 1
A	00.11.03	SCALE 1:3
	NEW ISSUE	



D2802-041 (SHOWN)
D2802-042 (OPPOSITE)



D2802-1 (SHOWN)
D2802-2 (OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35809

MACHINE PER DRAWING FILE "D2802-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00-11-13 *CP*